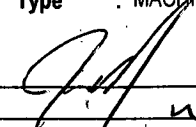



Date: Tuesday, 1/2/2007 1:28:51 PM  
User: Chantal Lavoie

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
<b>Job Number</b> : 30096	
<b>Estimate Number</b> : 10533	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2573
<b>This Issue</b> : 1/2/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2573 REV E
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : E
<b>Previous Run</b> : 29662	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 1/9/2007 <b>Qty:</b> 12 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est: 1 As Per RevE 06-01-27 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D6101007	7075-T7351 8.25X7.75X2.5
-----	----------	--------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2573

Ensure that grain is along 7.75" length

Batch No: 325355 x 12

Ep 07/01/07

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1

Program Batch No. 830096 Double check by: J.F.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

Ep / J.F. 07/01/18 (12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



**Comment:** CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

Ep / J.F. 07/01/18 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   *PD*   Date:   *07/01/22*  

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 1/2/2007 1:28:51 PM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 30096

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En/J.F. 07/01/18 (12)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.01.18

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

YJ/YC

07.01.18 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SR/a.m

07/01/19 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 7/01/22 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51471

PC 7/01/22 (12)

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/22 (12)

Job Completion



CL 07/01/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 300%
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.749	1.748	1.747		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.749	1.748	1.747		
E	7.990	8.010		8.000	8.002	8.002	8.003		
F	0.490	0.510		0.496	0.502	0.501	0.499		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.507	0.502	0.504	0.504		
J	1.174	1.184		1.177	1.177	1.178	1.176		
K	0.558	0.578		0.567	0.566	0.568	0.570		
L	1.174	1.184		1.177	1.177	1.178	1.176		
M	1.365	1.375		1.367	1.369	1.369	1.369		
N	2.495	2.505		2.497	2.498	2.499	2.501		
O	4.119	4.129		4.122	4.122	4.123	4.120		
P	0.115	0.135		0.127	0.127	0.126	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.255	0.250	0.249	0.250		
S	0.115	0.135		0.124	0.125	0.125	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.245	0.239	0.240	0.237		
W	0.115	0.135		0.126	0.125	0.125	0.126		
X	0.308	0.313		0.310	0.310	0.309	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.368	0.366	0.366	0.366		
AA	0.470	0.530		0.506	0.500	0.500	0.506		
AB	0.615	0.635		0.629	0.629	0.628	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.253	0.251	0.251	0.246		
AE	1.500	1.520		1.509	1.510	1.509	1.511		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.258	0.246	0.246	0.245		
AI	2.000	2.020		2.000	2.000	2.000	2.001		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by: E.P.
Date: 07/01/13

Audited by: J.F.
Date: 07/01/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 30096
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. E	<b>Page 1 of 1</b>

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A	0.438	0.443	<del>DT8682</del>	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.749	1.747	1.750		
C	3.495	3.505		3.498	3.499	3.499	3.500		
D	1.745	1.755		1.750	1.749	1.747	1.750		
E	7.990	8.010		8.003	8.003	8.004	8.003		
F	0.490	0.510		0.499	0.498	0.498	0.497		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.378	0.378	0.378	0.378		
I	0.490	0.510		0.504	0.504	0.506	0.505		
J	1.174	1.184		1.176	1.177	1.177	1.177		
K	0.558	0.578		0.567	0.568	0.567	0.567		
L	1.174	1.184		1.176	1.177	1.177	1.177		
M	1.365	1.375		1.366	1.371	1.371	1.371		
N	2.495	2.505		2.498	2.498	2.498	2.498		
O	4.119	4.129		4.123	4.120	4.120	4.120		
P	0.115	0.135		0.127	0.126	0.126	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.250	0.250	0.250		
S	0.115	0.135		0.126	0.121	0.126	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.236	0.238	0.237		
W	0.115	0.135		0.122	0.124	0.122	0.123		
X	0.308	0.313		0.310	0.309	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	0.369	0.367	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.629	0.629	0.626		
AC	0.053	0.073		0.068	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.248	0.245	0.244		
AE	1.500	1.520		1.513	1.512	1.511	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.248	0.245	0.248		
AI	2.000	2.020		2.002	2.002	2.001	2.002		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by: <i>En</i>
Date: 07/10/13

Audited by: <i>J.F.</i>
Date: 07/10/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 30096
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.749	1.750	1.754"		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.749	1.750	1.754		
E	7.990	8.010		8.005	8.004	8.004	8.002		
F	0.490	0.510		0.499	0.499	0.498	0.501		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.378	0.378	0.378	0.378		
I	0.490	0.510		0.502	0.504	0.501	0.505"		
J	1.174	1.184		1.177	1.177	1.177	1.177"		
K	0.558	0.578		0.567	0.568	0.567	0.570"		
L	1.174	1.184		1.177	1.177	1.177	1.177"		
M	1.365	1.375		1.369	1.370	1.369	1.373		
N	2.495	2.505		2.500	2.500	2.500	2.500"		
O	4.119	4.129		4.120	4.120	4.120	4.126		
P	0.115	0.135		0.126	0.126	0.127	0.128"		
Q	0.115	0.135		0.135	0.135	0.135	0.135"		
R	0.240	0.260		0.250	0.251	0.250	0.250"		
S	0.115	0.135		0.125	0.126	0.124	0.127"		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.238	0.238	0.244		
W	0.115	0.135		0.123	0.124	0.124	0.126		
X	0.308	0.313		0.316	0.310	0.310	0.311"		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	0.366	0.366	0.372"		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.626	0.627	0.633		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.247	0.245	0.249		
AE	1.500	1.520		1.511	1.511	1.510	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.251	0.249	0.253		
AI	2.000	2.020		2.000	2.000	2.000	2.001		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

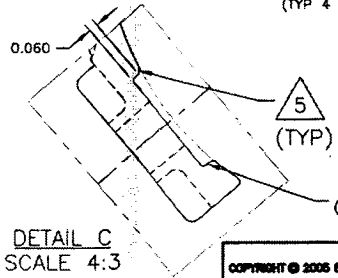
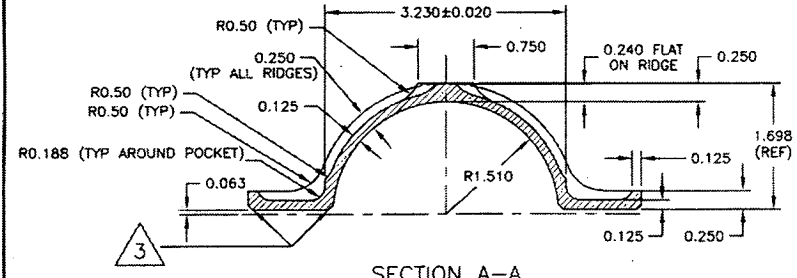
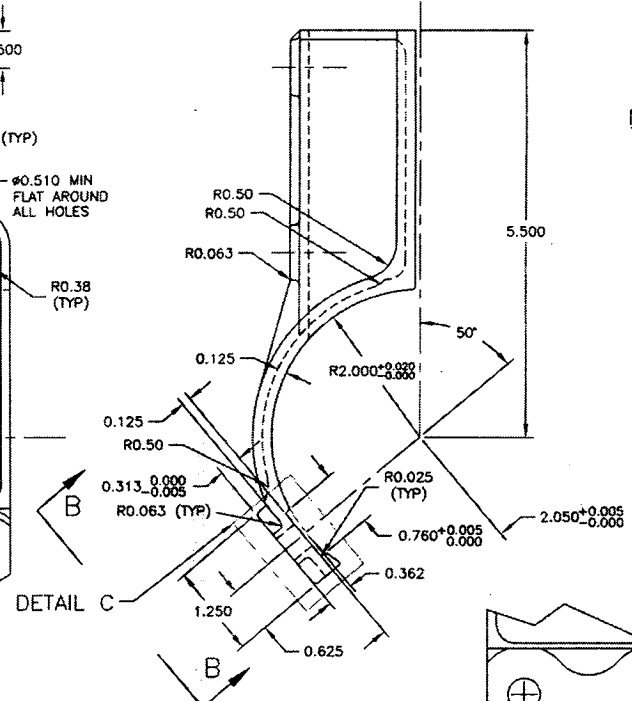
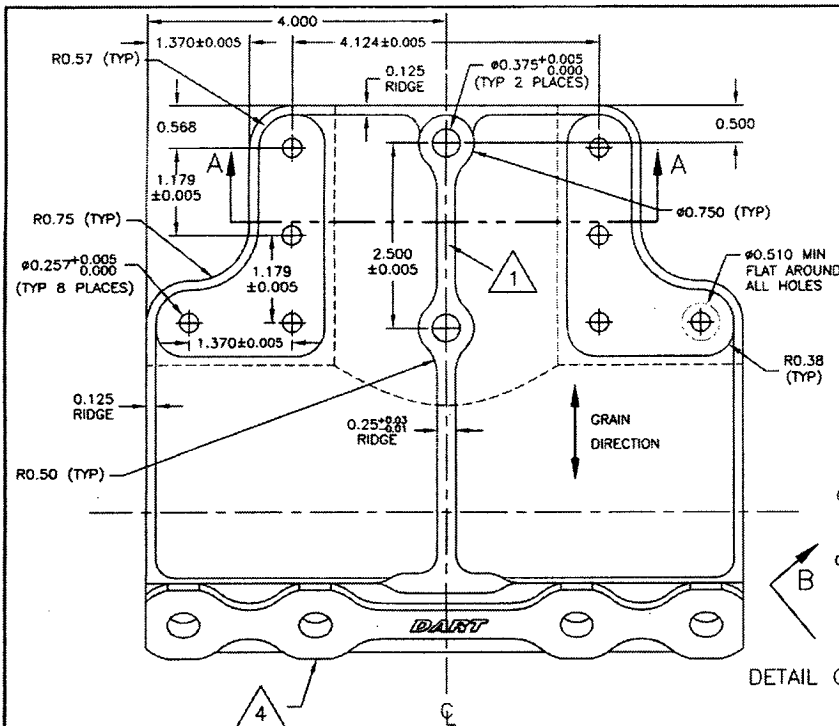
Measured by: E.A. / J.F.
Date: 07/01/16

Audited by: SA
Date: 01.01.16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06

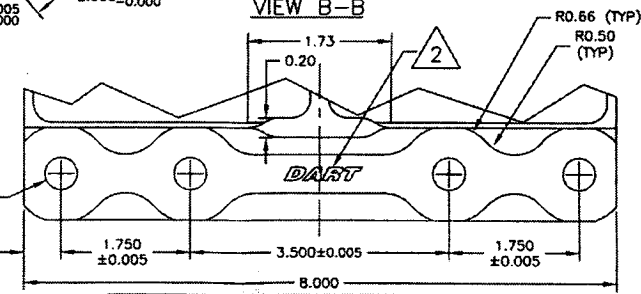


# NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C) E

## VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR. 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DS	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD.	REV. E
CHECKED	#	APPROVED	#	DRAWING NO.	D2573	SHEET 1 OF 1
DATE	05.07.13	TITLE	OUTER AFT SADDLE			
						SCALE
						2:3

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010 30096